

154014

Wednesday, November 30, 2016 4:02:27 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/6/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/9/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:	DAS 21	Date:	DEC 01 2016	Tooling:		Date:	
QC:	9-89	Date:		SPC (Y/N):		Date:	

Run Start *NR1*

Stop *NR2*

[illegible]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

DQA: _____ Date: _____

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Work Order ID 154014

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154014

Page 3

Item ID: D3574-2**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Cabin Floor Protector**Start Date:** 12/6/2016 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 12/9/2016 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>PK</u>	0.00							
150									
Packaging	Memo	0.00				1	DAS 6 9-89		
Packaging									DEC 09 2016
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.02					DAS 21 9-89		DEC 12 2016
Quality Control									
							DAS 21 9-89		DEC 09 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

Wednesday, November 30, 2016 4:02:26 PM

Work Order ID: 154014

154014

Parent Item: D3574-2

D3574-2

Parent Item Name: Cabin Floor Protector

Start Date: 12/6/2016

Required Date: 12/9/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04

Purchased

No

sf

4,848.842

25.35294

DAS
46
9-89

16/12/06

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET (DARK GREY)

Location

Loc Qty

Loc Code

MAT018

4848.842353

m135074

1008.84235

m136228

3840

23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
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Root Cause		FAULT CATEGORY																							
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DART AEROSPACE LTD		Work Order: 154014
Description: Cabin Floor Protector		Part Number: D3574-2
Inspection Dwg: D3574	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.002	✓		De-ol	
7.37	+/-0.030	7.37	✓		tape	
10.75	+/-0.030	10.75	✓			
11.00	+/-0.030	11.00	✓			
15.25	+/-0.030	15.25	✓			
25.87	+/-0.030	25.87	✓			
39.75	+/-0.030	39.75	✓			
44.75	+/-0.030	44.75	✓			
53.51	+/-0.030	53.51	✓			
63.50	+/-0.030	63.50	✓			
65.25	+/-0.030	65.25	✓			
10.75	+/-0.030	10.75	✓			
11.00	+/-0.030	11.00	✓			
14.75	+/-0.030	14.75	✓			
25.50	+/-0.030	25.50	✓			
25.75	+/-0.030	25.75	✓			
26.00	+/-0.030	26.00	✓			
32.87	+/-0.030	32.87	✓			
38.81	+/-0.030	38.81	✓			
45.00	+/-0.030	45.00	✓			
48.25	+/-0.030	48.25	✓			
58.38	+/-0.030	58.38	✓			
61.25	+/-0.030	61.25	✓			
64.13	+/-0.030	64.13	✓			
64.63	+/-0.030	64.63	✓			
66.50	+/-0.030	66.50	✓			
7.50	+/-0.030	7.50	✓			
9.50	+/-0.030	9.50	✓			
10.38	+/-0.030	10.38	✓			
10.88	+/-0.030	10.88	✓			
14.50	+/-0.030	14.50	✓			
16.56	+/-0.030	16.56	✓			
18.75	+/-0.030	18.75	✓			
24.13	+/-0.030	24.13	✓			

DART AEROSPACE LTD		Work Order:	154014
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

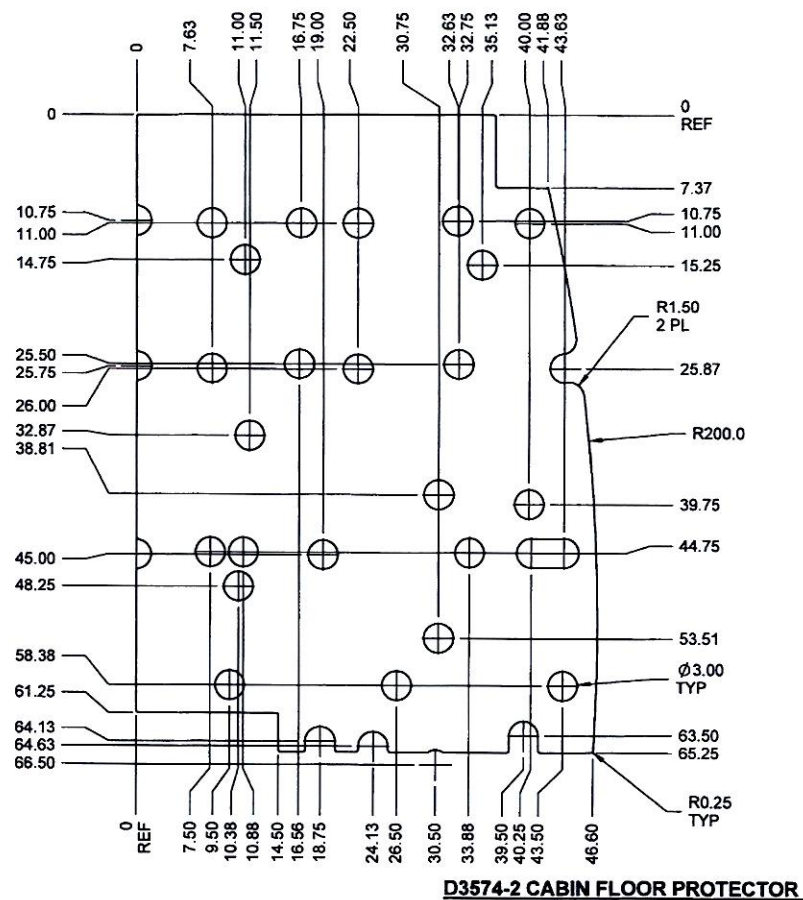
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50	✓		Pc-01	
30.50	+/-0.030	30.50	✓		tape	
33.88	+/-0.030	33.88	✓			
39.50	+/-0.030	39.50	✓			
40.25	+/-0.030	40.25	✓			
43.50	+/-0.030	43.50	✓			
46.60	+/-0.030	46.60	✓			
7.63	+/-0.030	7.63	✓			
11.00	+/-0.030	11.00	✓			
11.50	+/-0.030	11.50	✓			
16.75	+/-0.030	16.75	✓			
19.00	+/-0.030	19.00	✓			
22.50	+/-0.030	22.50	✓			
30.75	+/-0.030	30.75	✓			
32.63	+/-0.030	32.63	✓			
32.75	+/-0.030	32.75	✓			
35.13	+/-0.030	35.13	✓			
36.50	+/-0.030	36.50	✓			
40.00	+/-0.030	40.00	✓			
41.88	+/-0.030	41.88	✓			
43.63	+/-0.030	43.63	✓			
0.125	DAS +/-0.010	0.132	✓			

Measured by:	DAS 46 9-89	Audited by:	DAS 38 9-89	Prototype Approval:	N/A
Date:	16/12/06	Date:	DEC 19 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	



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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154014 MJS

16-12-01 **RELEASED**
09/04/01 MJS

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D3574	SHEET 2 OF 6
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	CABIN FLOOR PROTECTOR	
DATE	09.03.25	NTS	
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